

Date: Wednesday, 6/6/2007 1:47:55 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 32772					
Estimate Number	: 11029					
P.O. Number	: N/A			Part Number	: D2803041	
This Issue	: 6/6/2007		S.O. No.	: N/A		
Prsh Rev.	: NC			Drawing Number	: D2803 REV B	
First Issue	: N/A			Project Number	: N/A	
Previous Run	: 29391			Drawing Revision	: B	
Written By				Material	: N/A	
Checked & Approved By				Due Date	: 6/30/2007	
Comment	: EST F 05.03.30 MS21043-3 was MS21042L3			Qty:	10	Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28031	STA 84 Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STA 84 BRACKET	
		Pick: Qty Part Number Description Batch	 <i>B32800 X10 ✓ ml</i>
2.0	D28051	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STOP	 <i>B30819 X1 ✓ B34073 6 ml</i>
3.0	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing	 <i>B30149 ✓ ml 07-08-3</i>
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-1 into arm as per Dwg D2803	 <i>ml 07-08-28 10</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/03/29	b	Split u/o white		80	07/08/29	3		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32772		Part Number: D2803041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC5	INSPECT WORK TO CURRENT STEP
6.0	POWDER COATING	7 Pcs - Powder Coating Green Sand Tex 3 Pcs - White M10,5008 3x white
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
9.0	AN3C16A	Bolt
10.0	MS210433	Nut
11.0	NAS1515H3	Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/09/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET ASSEMBLY

Job Number: 32772

Part Number: D2803041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

MF 07-08-31(3)

13.0 QC5

INSPECT WORK TO CURRENT STEP.



Comment: INSPECT WORK TO CURRENT STEP

Eo 07/09/04(43)

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

ST150

C 7/9/4 (3)

15.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

NOK/OK

Job Completion



U 8/9/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								*

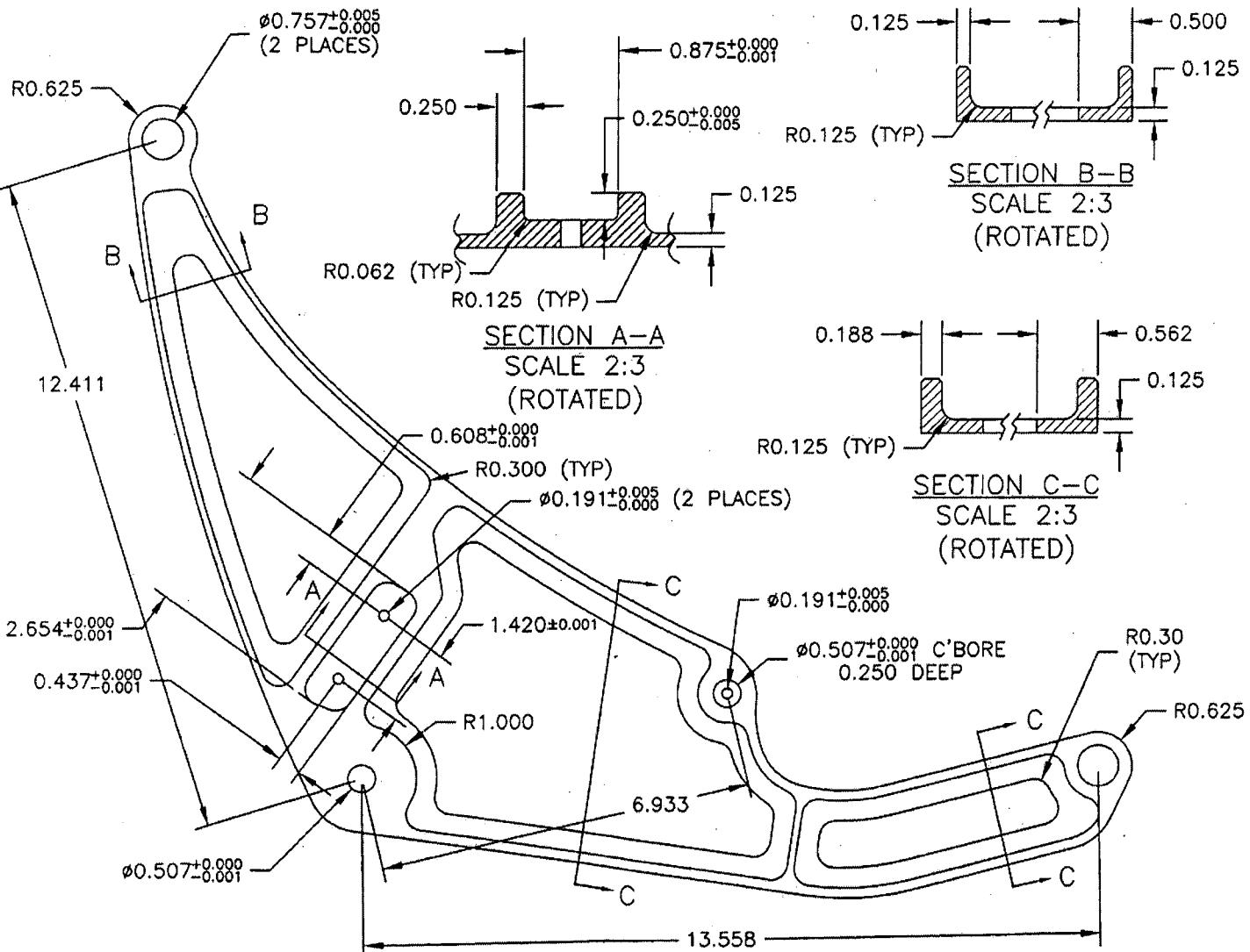
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 ~~eff~~



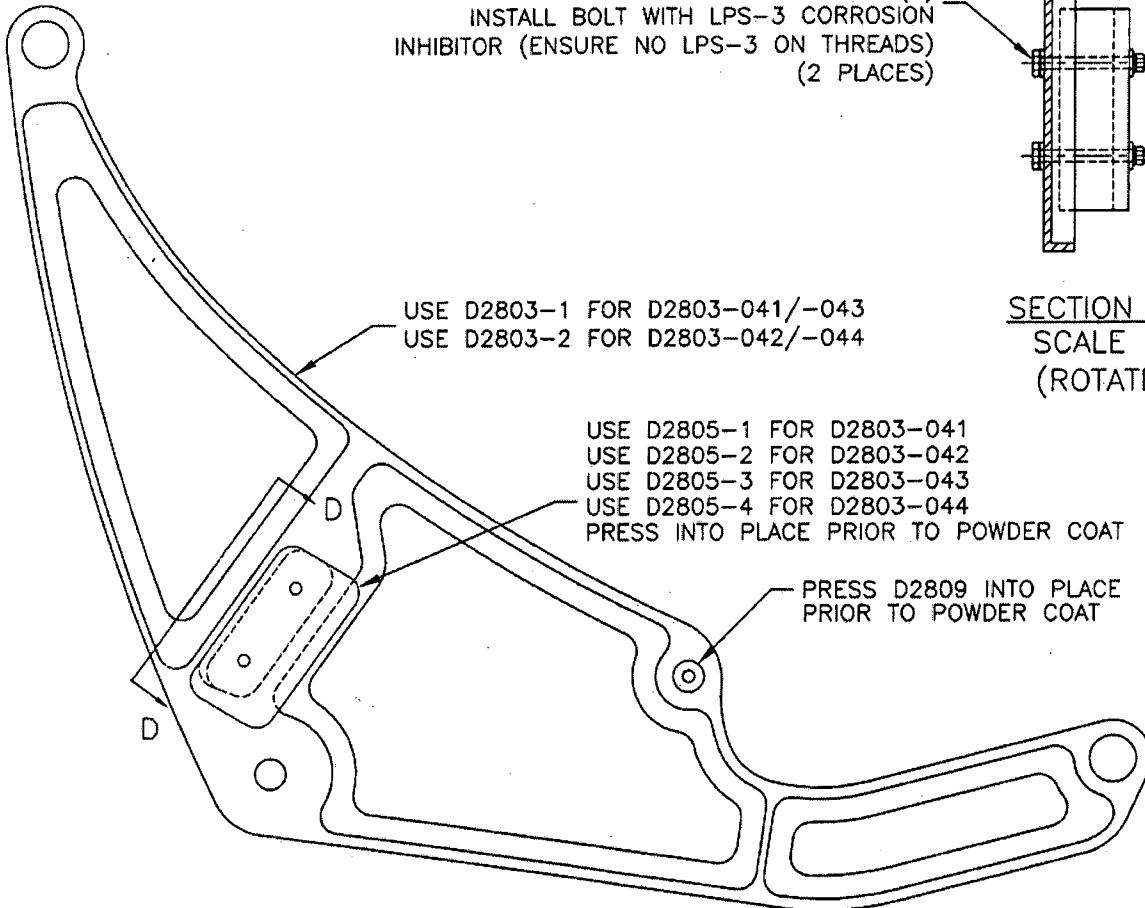
D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
  - 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
  - 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
  - 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 30772

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



D2803-041/-043 BRACKET ASS'Y (SHOWN)  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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05-03-11  
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WORK ORDER  
NO. 32772